

Split -2

Order ID 98952-2

28-13 10:47:22 AM

98952

Page 1

Item ID: D3183-9

Revision ID:

Item Name: Cap

Start Date: 3/27/13

Required Date: 3/27/13

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Start Qty: 60.00

60

Req'd Qty: 60.00

60

Cust Item ID:

Customer:

Approvals:

Process Plan: MLC

Date: 13-03-28

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3183

Rev C1

100

100

Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

Turn D3183-9 Cap as per Folio FA388Debur

0.00

0.00

PD 13/04/08
13/03

49
50 0

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

PD 13/04/08

49
50 0

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

13-04-11

49 0

Work Order ID 98952

March-28-13 10:47:22 AM

98952

Page 2

Item ID: D3183-9

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cap

Start Date: 3/27/13

Start Qty: 60.00

60

Cust Item ID:

Required Date: 3/27/13

Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

130

Identify as per dwg & Stock Location: **8T235B** 0.00

130

Packaging

Memo

0.00

Packaging

49x

80
13-4-12

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

13/4/15

1304-12

Picklist Print

March-28-13 10:47:22 AM

Page 1

Work Order ID: 98952

Parent Item: D3183-9

Parent Item Name: Cap

Start Date: 3/27/13

Required Date: 3/27/13

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP A 06.05.03 New issue KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELINR1.000 Delrin Round Bar 1"		Purchased	No			100	f	2.6700	0.0333	2.1031579			

30 13/04/08

125"
this batch
only good
13.01.08

Location

MAT018

124942

Loc Qty

2.67

2.67

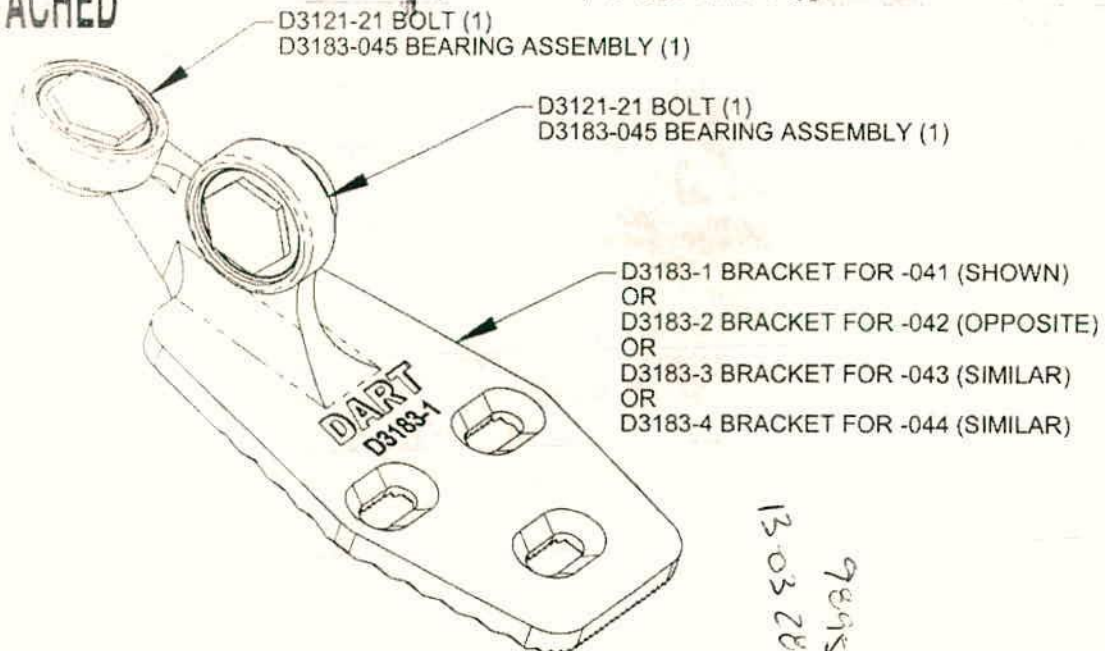
Loc Code

121971

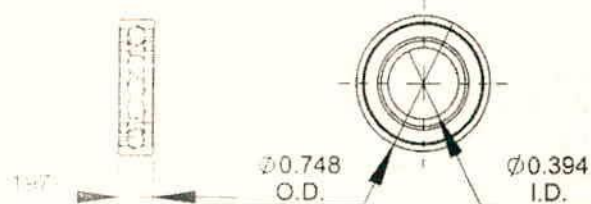
1.9

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	

DEO ATTACHED

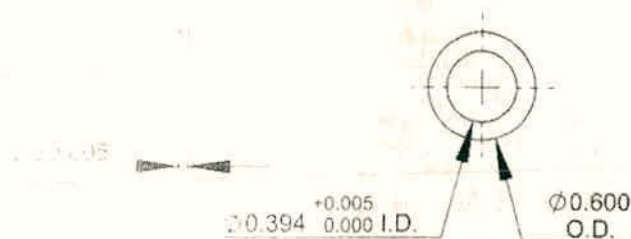


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING: **SPECIFICATION CONTROL DRAWING**

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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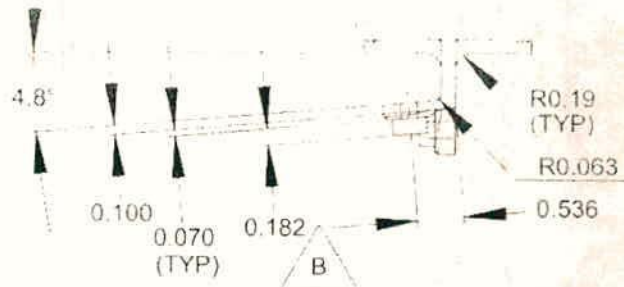
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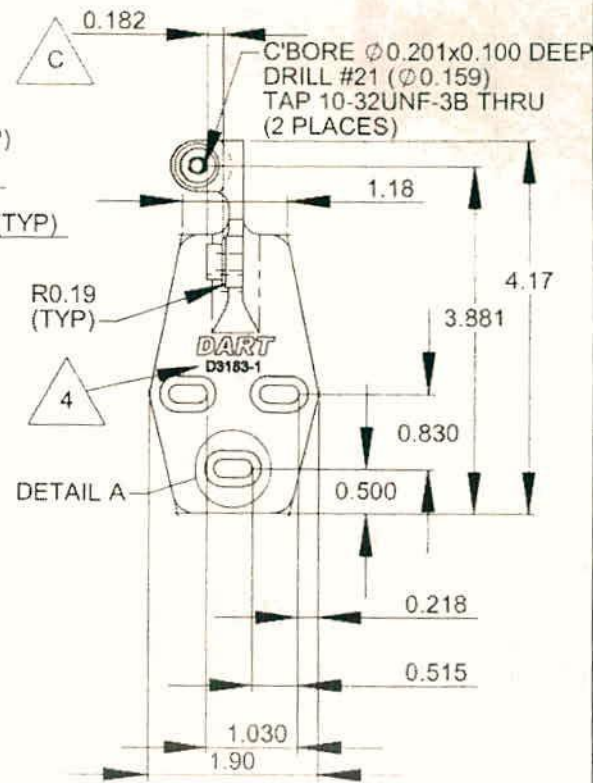
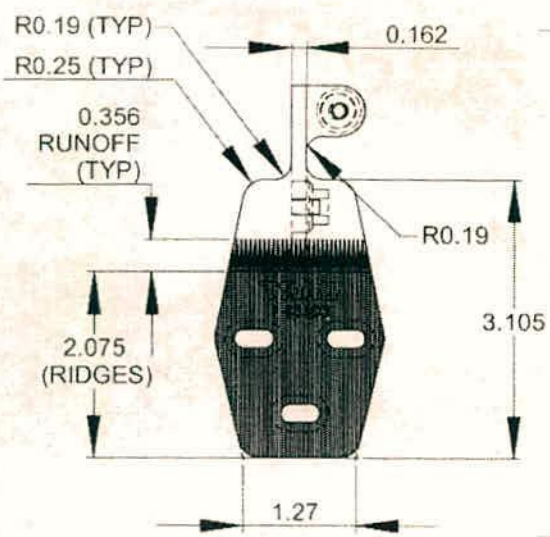
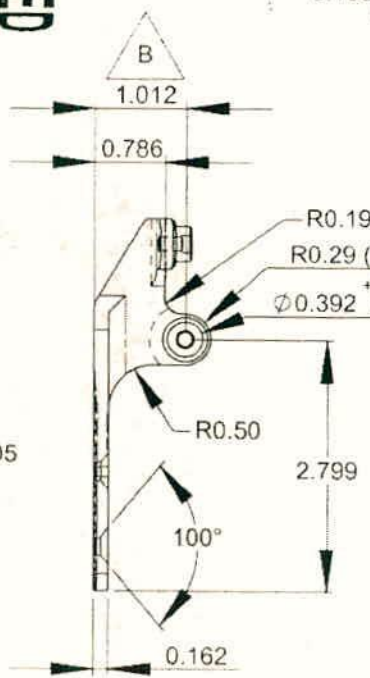


DESIGN	DRAWN BY	DART Aerospace Ltd
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. C
04.02.17	D3183	SHEET 2 OF 4
	BRACKET ASSEMBLY	SCALE 1:2

SEE DETAIL B



DEO ATTACHED



D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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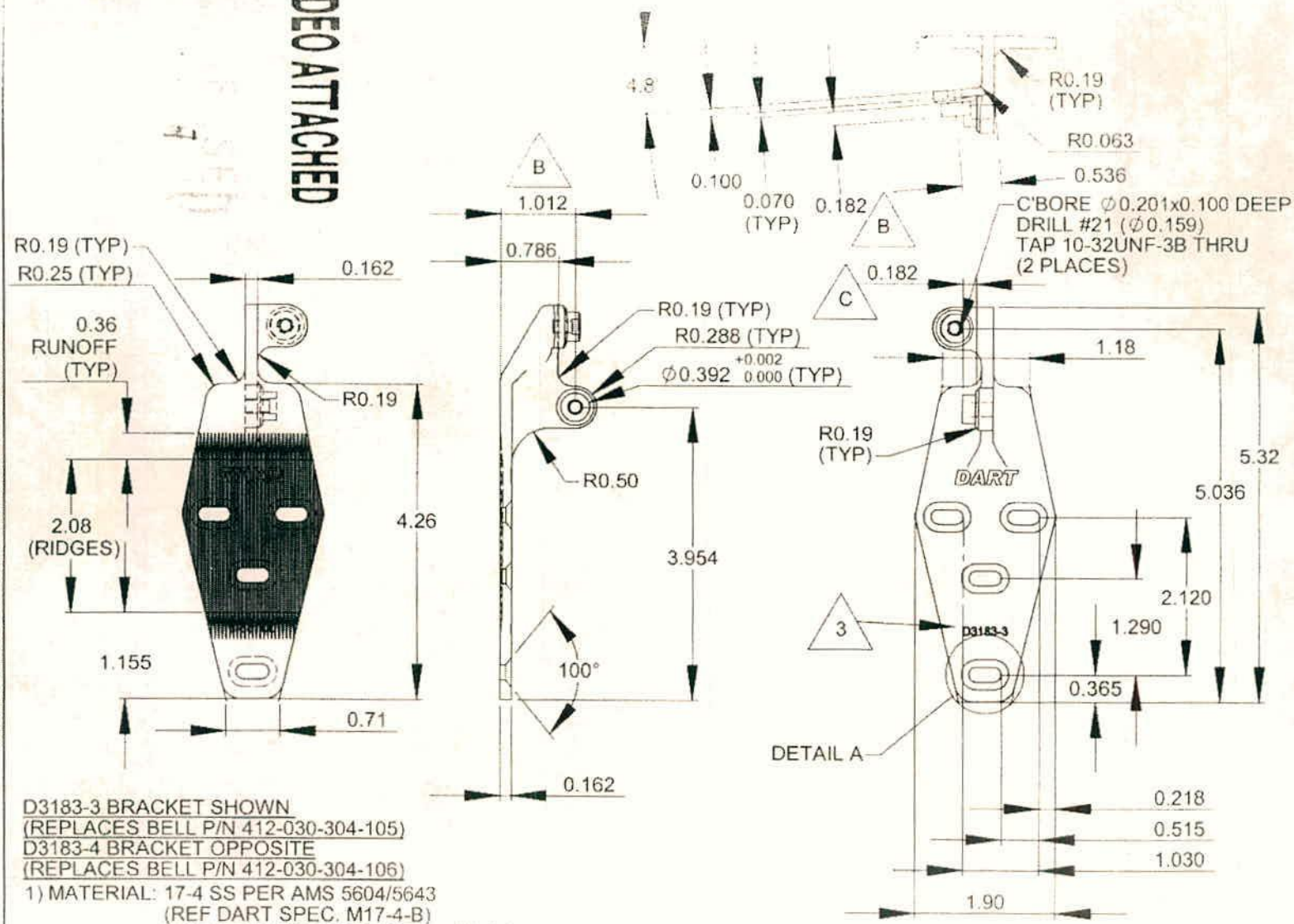
98952



DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	SHEET 3 OF 4
DATE	TITLE	DRAWING NO.	SCALE
04.02.17	BRACKET ASSEMBLY	D3183	1:2

SEE DETAIL B

DEO ATTACHED







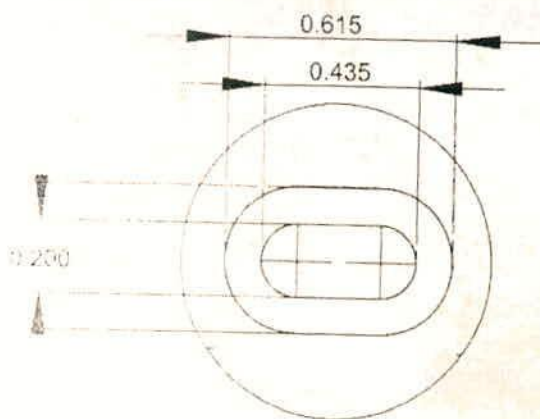
D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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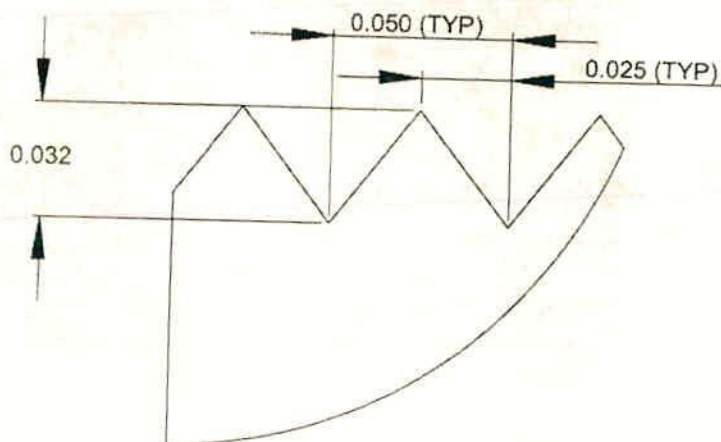
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DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1

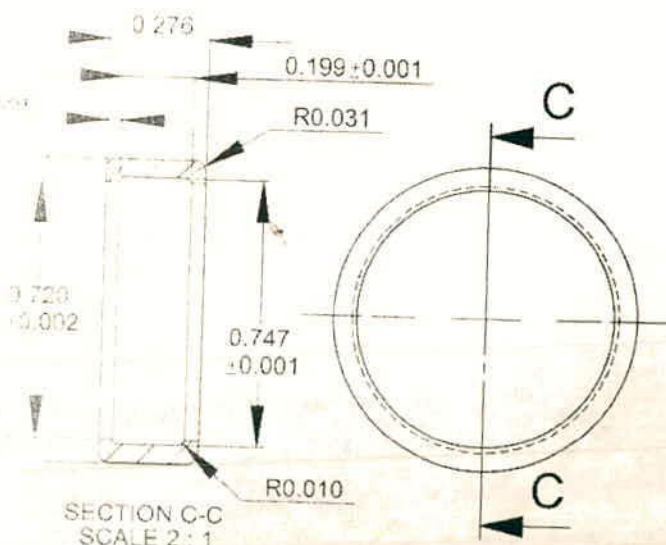


DETAIL A (2 : 1)

DEO ATTACHED



DETAIL B (20 : 1)



**SECTION C-C
SCALE 2 : 1**

D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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25626

98952

DRAWING NO. D3183	TITLE BRACKET ASSEMBLY	REV.C1	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3183-C1-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 92	CHECKED J	MFG. APPR. M	APPROVED MP	DE APPR. MP			
DATE 10.05.14	DATE 10.06.30	DATE 10.06.30	DATE 10/06/30	DATE 10/06/30			

D3183-5 BEARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT: Cr = 1720 N (386 lb) MIN [DYNAMIC]
Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012

RELEASED
2010-07-22
MP